






Work Order ID 65495



January 19, 2011 7:58:19 AM



Page 1


Item ID: D4190-041 Accept  Setup Start 
 Revision ID: PRELIM Stop 
 Item Name: External Bellcrank Assembly
 Start Date: 1/19/11 Start Qty: 2.00  Cust Item ID:
 Required Date: 2/04/11 Req'd Qty: 2.00  Customer:


Reference:


Approvals: Process Plan: CL Date: 11/01/19 Tooling: _____ Date: _____ Run Start 
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4190	<u>PAT PA6 PA9</u> <u>11-03-31</u>

100	Pick Kit	0.00							
	Packaging	0.00							
	Packaging								

110		0.00							
	Small Fab	0.00							
	Small Fab								

120	QC5- Inspect part completeness to step on W/O	0.00							
	QC	0.00							
	Quality Control								



PRELIMINARY ISSUE

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

January 19, 2011 7:58:19 AM

Accept

1. The first step in the process is to identify the problem or issue that needs to be addressed. This involves gathering information and understanding the context of the problem.

2. Once the problem is identified, the next step is to define the objectives and goals of the project. This helps to clarify what needs to be achieved and provides a clear direction for the team.

3. The third step is to develop a plan or strategy to address the problem. This involves breaking down the problem into smaller, manageable tasks and determining the resources needed to complete each task.

4. The fourth step is to implement the plan. This involves putting the strategy into action and monitoring progress regularly to ensure that the project is on track.

5. The final step is to evaluate the results of the project. This involves comparing the actual outcomes against the objectives and goals to determine the effectiveness of the project.

Setup Start

Stop

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Cust Item ID:

Required Date: 2/04/11 Req'd Qty: 2.00

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Operation Description

Set Up/ Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

Identify as per dwg & Stock Location:

0.00

RESEARCH

Packaging

Memo

0.00

Packaging

140

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

PL 11-06-9
(2)

EFFECTIVE 11/01/91

AUTH W

RELEASED _____ DATE _____

DATE _____

RD 1344.

Pulled on D4195-041

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

'Picklist Print

Page 1

January 19, 2011 7:58:05 AM

Work Order ID: 65495



Parent Item: D4190-041



Parent Item Name: External Bellcrank Assembly







Start Date: 1/19/11

Required Date: 2/04/11

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A NEW ISSUE 11-01-12 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4190-1  Bellcrank		Manufactured	No				Each	0.0000		2			<i>B65499 JLM</i>
NAS77C3-011  Bushing		Purchased	No				Each	0.0000		2			<i>M116750 JLM</i>
NAS75C3-008  Bushing		Purchased	No				Each	0.0000		2			<i>M116738 JLM</i>

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

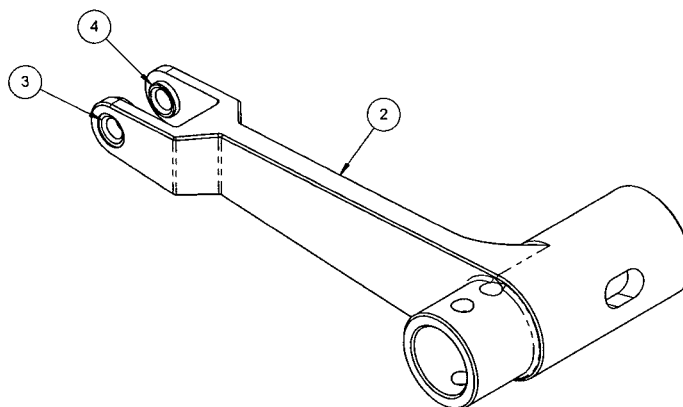
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM NO.	QTY. .041	PART NUMBER	DESCRIPTION
1	X	D4190-041	EXTERNAL BELLCRANK ASSEMBLY
2	1	D4190-1	EXTERNAL BELLCRANK
3	1	NAS77C3-011	BUSHING
4	1	NAS75C3-008	BUSHING (ALT - NAS537C3-025)



D4190-041 EXTERNAL BELLCRANK ASSEMBLY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 65495
C21110119

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.55 lbs
- 8) NAS77C3-011 BUSHING IS A PRESS FIT
- 9) NAS75C3-008 BUSHING IS A FLOATING FIT

PRELIMINARY ISSUE

10.11.16

PAGE	NEW ISSUE	BY	10.11.16
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
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DATE	10.11.16		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D4190	REV. PA6 SHEET 1 OF 2
TITLE BELLCRANK	SCALE NTS
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W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

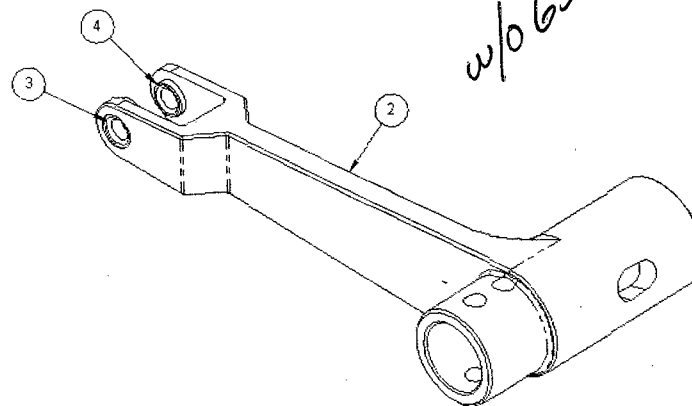
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM NO.	QTY. .041	PART NUMBER	DESCRIPTION
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2	1	D4190-1	EXTERNAL BELL CRANK
3	1	NAS77C3-011	BUSHING
4	1	NAS75C3-008	BUSHING (ALT - NAS537C3-025)



D4190-041 EXTERNAL BELL CRANK ASSEMBLY

PRELIMINARY ISSUE

10.11.16

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PA9	NEW ISSUE	DESCRIPTION	BY	DATE
REV.				
DESIGN		DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA		
DRAWN		DRAWING NO.	REV. PA9	
CHECKED		D4190	SHEET 1 OF 2	
MFG. APPR.		TITLE	SCALE	
APPROVED		BELL CRANK	NTS	
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